



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5445-042
Job Sheet 175968



Part No: D5445-042

Job Qty: 2 ea

Part Name: Longitudinal Beam Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/13/18

Job Tracking No:

Due Date: 4/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5445 REV C SHEETS 2,5 IPP REV:A 17.01.10 NEW ISSUE DD VERF:JLM IPP REV:B 17.11.15 REVISE
AS PER INTUITIVE INSTRUCTION DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/19/18	4/19/18	0.00	0.00	Start Up Skidtubes-1		
100	CNC Bend Skidtubes	2 pcs	4/19/18	4/19/18	0.00	2.00	CNC Bend Skidtube		
110	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC2 QC5		
120	Mill Conv	2 pcs	4/19/18	4/19/18	0.00	2.00	Mill Conv 1		
130	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC2		
140	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC8		
150	HandFinish	2 pcs	4/19/18	4/19/18	0.00	1.00	HandFinish1		
160	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC7		
170	Small Fab	2 pcs	4/19/18	4/19/18	0.00	2.00	Small Fab		
180	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC5		
184	Skidtubes	2 pcs	4/19/18	4/19/18	0.00	1.00	Skidtubes-2		
186	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC5		
190	Powdercoat	2 pcs	4/19/18	4/19/18	0.00	1.00	Powdercoat1		
200	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC3		
210	HandFinish	2 pcs	4/20/18	4/20/18	0.00	1.00	HandFinish4		
220	QC	2 pcs	4/20/18	4/20/18	0.00	0.00	QC5		
230	Packaging	2 pcs	4/20/18	4/20/18	0.00	0.00			
240	QC21-SA	2 Ea	4/20/18	4/20/18	0.00	0.00	QC21		

Part Op 100 - BEND/CUT AS PER DWG

Descriptions: 120 - -MILL/DRILL AS PER DWG. -insure proper orientation -DEBURR

170 - INSTALL NUT PLATES AS PER DWG

184 - 1- Pick (4) D4720-1 space for each beams and chemical convert them. 2- Swage x-bolt spacers as per dwg. Trim off excess material as required. 3- After swaging, ream x-spacer hole if necessary to finish size. 4- Touch up alodine after swaging. 5-INSTALL END CAP

190 - ***MASK NUT PLATE HOLES*** START TIME: 1:40 OVEN TEMPERATURE: 320° FINISH TIME:

2:10 M 138439
210 - SEAL END CAPS WITH SIKAFLEX AS PER NOTE 11

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6TR1.5X1.0W125	6061-T6 Rect Tube 1.5 X 1.0 X .125W	12 ft (6 ea)	90-Start up Operation	
CR2672-3-(03)	Cherry Rivet	16 Ea (8 ea)	170-Small Fab	5057524
MS21059-4	Nut Plate	6 Ea (3 ea)	170-Small Fab	5065256
MS21061L4	Nutplate	2 Ea (1 ea)	170-Small Fab	5065257



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S064271



Part: D5445-042

Job No: 175968

Serial No/Batch: S064271

Revision: C

Inspector:

Date: 04/24/18

10

D4720-1
D5445-043
MS24694-S3

Spacer
End Cap Assembly
Screw

8 Ea (4 ea) 184-Skidtubes
4 Ea (2 ea) 184-Skidtubes
8 Ea (4 ea) 184-Skidtubes

SO30687
K158775
M136643

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Setup Operation	M6061T6TR1.5X1.0W125	12	48	0
170-Small Fab	CR2672-3-(03)	16	111	0
	MS21059-4	6	8	0
	MS21061L4	2	4	0
184-Skidtubes	D4720-1	8	402	0
	D5445-043	4	30	0
	MS24694-S3	8	59	0

Part Specifications

Specifications could not be found.

Plex 4/13/18 7:10 AM Dart.lajeunesse.marie

ITEM	QTY -042	P/N	DESCRIPTION
	X	D5445-042	LONGITUDINAL BEAM ASSEMBLY, RH
1	2	D5445-043	END CAP ASSEMBLY
2	1	D5445-2	LONGITUDINAL BEAM, RH
3	4	D5445-5	SPACER
4	8	CR2672-3-(03)	RIVET CHERRY, CSK
5	3	MS21059-4	NUT PLATE
6	1	MS21081L4	NUT PLATE
7	4	MS24694-S3	SCREW, CSK 100°
8	A/R	SIKAFLEX-241/-291	SEALANT

DETAIL D

DETAIL C

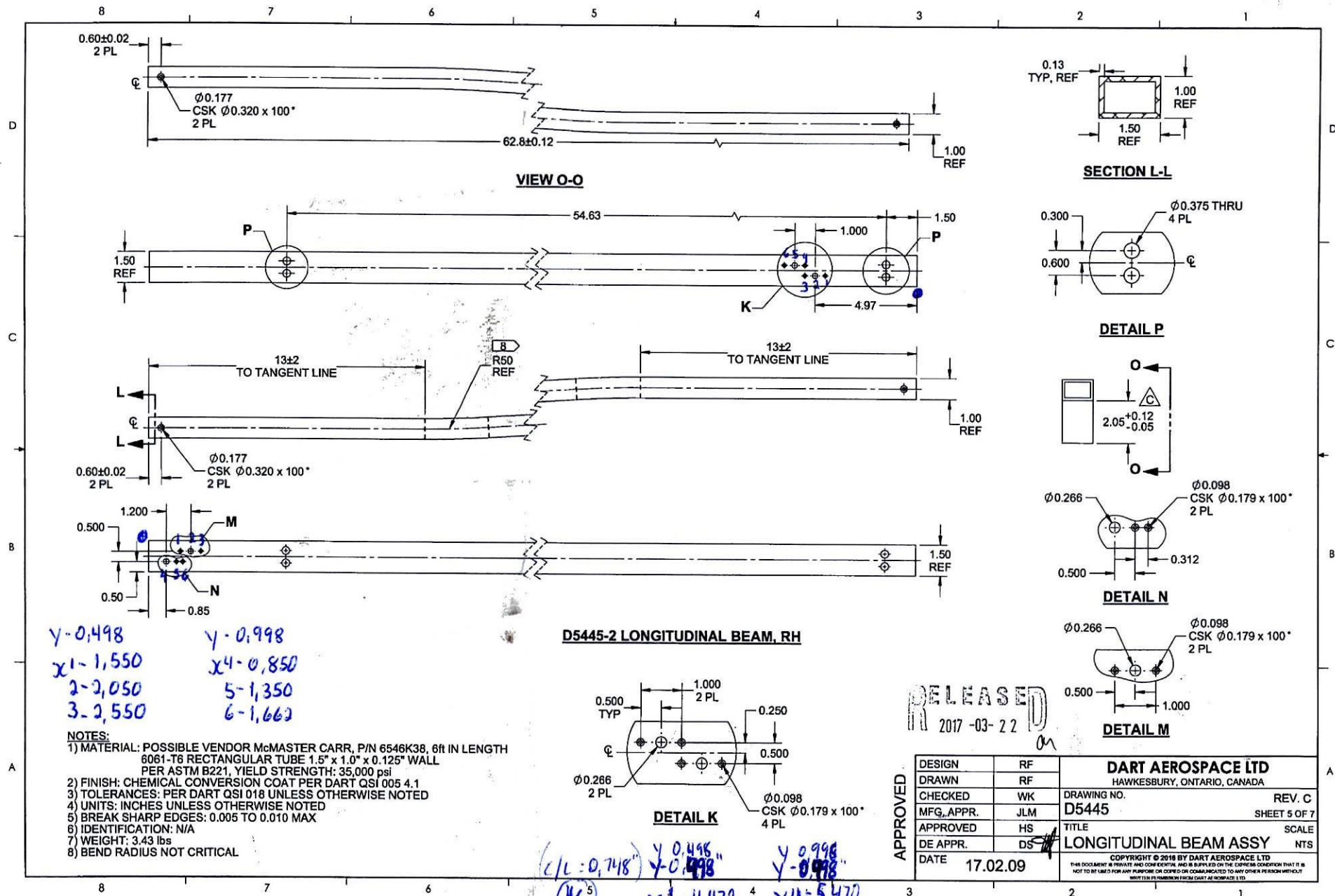
D5445-042 LONGITUDINAL BEAM ASSEMBLY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.50 lbs
- 8) SWAGE TO $\phi 0.313$ THRU PER QSI 002 4.2
- 9) TRIM/GRIND FLUSH PER QSI 002
- 10) REAM THRU SPACERS USING $\phi 0.313$ REAMER
- 11) SEAL END CAPS WITH SIKAFLEX-241/-291
- 12) MASK HOLES PRIOR TO POWDER COAT

RELEASED
2017-03-22
APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WK	DRAWING NO.	REV. C
MFG. APPR.	JLM	D5445	SHEET 2 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LONGITUDINAL BEAM ASSY	NTS
DATE	17.02.09	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order: 175968
Description: Longitudinal Beam Assy - RH		Part Number: 05445-2
Inspection Dwg: Same as P/N Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62.8"	$\pm 0.12"$	62.80	✓		Tape	
1.00 Ref	± 0.030	0.997	✓		Verier CLK-19	
1.50 "	$\pm "$	1.496	✓		"	
0.13 "	$\pm "$	0.118	✓		"	
all 0.60 2 places	± 0.030	0.600	✓		"	
all 0.177	$\pm 0.002/-0.001$	0.178	✓		"	
all CSK 0.320 x 100°	"	0.320	✓		"	CSK 100°
0.85	± 0.030	0.850	✓		Verier CLK-19	
1.200	± 0.010	1.200	✓		"	
0.500	"	0.500	✓		"	
0.50	± 0.030	0.500	✓		"	
54.63	$\pm "$	54.625	✓		Tape	
1.50	"	1.500	✓		Verier CLK-19	
0.600	± 0.010	0.600	✓		"	
0.300	"	0.300	✓		"	
0.375	$\pm 0.006/-0.001$	0.378	✓		"	
1.000	± 0.010	1.000	✓		"	
4.970	± 0.030	4.970	✓		"	
2.05	$\pm 0.12 / -0.05$	2.175	✓		"	
0.266	$\pm 0.006 / -0.001$	0.267	✓		"	
0.500	± 0.010	0.500	✓		"	
0.312	"	0.312	✓		"	
all 0.098	$\pm 0.005 / -0.001$	0.099	✓		"	
all 0.179 x 100°	$\pm "$	0.180	✓		Verier CLK-19	CSK
all 0.500	± 0.010	0.500	✓		Verier CLK-19	
all 1.000	"	1.000	✓		"	
0.250	"	0.250	✓		"	
0.500	"	0.500	✓		"	

DAS
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Measured by: [Signature]	Checked by: [Signature]	QC Inspector:
Date: 18/5/14	Date: 15/05/15	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	